

Date: Tuesday, 08/07/2008 12:44:25 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LATCH ASSEMBLY  
 Job Number : 40366  
 Estimate Number : 13370  
 P.O. Number :  
 This Issue : 08/07/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D3589041  
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : D3589 REV B PRELIM  
 Previous Run : 05031 Project Number : N/A 08.06.26  
 Drawing Revision : B PRELIM  
 Material :  
 Due Date : 15/07/2008 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev:A new issue 08-06-05 DD verified by:ec



## Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 Pick Packing Kit

2.0	D35891	ARM
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 ARM  
 batch: 640367 PD 08-07-21

3.0	D35893	ARM GUIDE
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 ARM GUIDE  
 batch: 640368 PD 08-07-21

4.0	D35897	AFT GUIDE PLATE
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 AFT GUIDE PLATE  
 batch: 640372 PD 08-07-21

5.0	D35899	FWD GUIDE PLATE
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 FWD GUIDE PLATE  
 batch: 640373 PD 08-07-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 08/07/2008 12:44:25 PM  
User: Liqda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH ASSEMBLY

Job Number: 40366

Part Number: D3589041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D358911

FWD GUIDE PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

FWD GUIDE PLATE

batch: B40371

PD 08-07-21

7.0

D358913

LUG



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

LUG

batch: B40369

PD 08-07-21

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- assemble and weld D3589-9 to D3589-11 as per dwg D3589

2- grind weld flush as per dwg D3589

3- slide (4) D3589-3 Arm Guides on D3589-1 Arm and weld D3589-13 lugs on both ends as per dwg D3589

\*\*\* ensure that the 4 ARM GUIDES are on the ARM before welding both LUGS\*\*\*

4- using door as a template install parts on door and weld as per dwg D3589 QSI004

304 Stainless Steel Rod Batch: M105524

PD 08-07-21

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/07/21 (1)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-07-21 (1)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

12.0

AN960JD4

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: \_\_\_\_\_

N/A THIS W/O. 08-08-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Date: Tuesday, 08/07/2008 12:44:25 PM  
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Drawing Name: LATCH ASSEMBLY

Job Number: 40366

Part Number: D3589041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D358915

LINK



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

LINK

batch: 040370

08.08.05

14.0

MS203921C7

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pin

batch:

15.0

MS246651010

COTTER PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

COTTER PIN

batch:

16.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per dwg D3589

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

TO REPLACE D3589-0A1 B/N B05031 ON  
D412-761-011 B/N 00224 THAT WILL BE

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SENT TO  
EAGLE CORP.  
FOR FLIGHT TEST  
08.08.05

Job Completion



POSITIVE RECALL

EFFECTIVE 08-07-08

RELEASED

AUTH

DATE

09-02-19

09-02-19

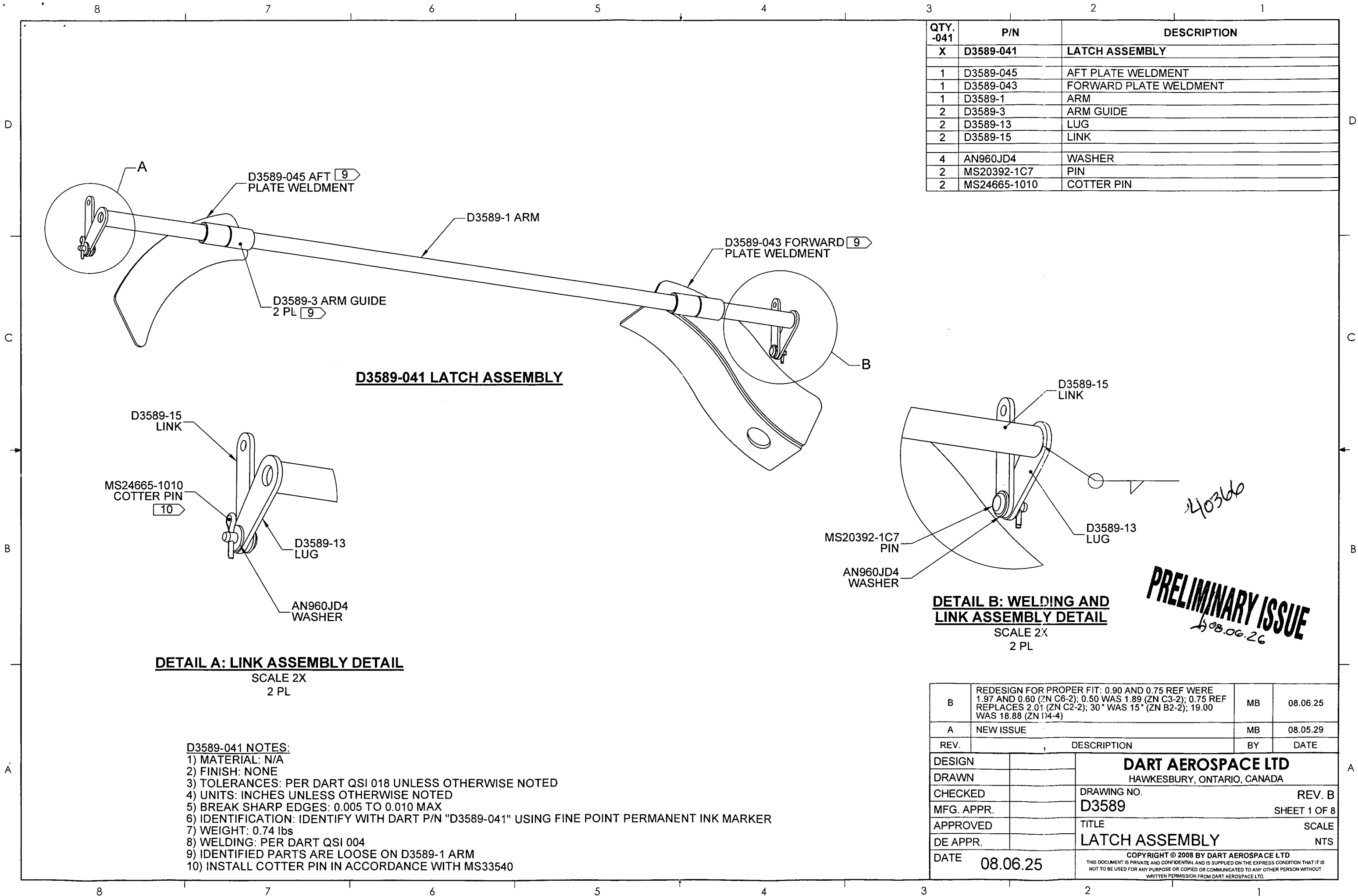
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



QTY. -041	P/N	DESCRIPTION
X	D3589-041	LATCH ASSEMBLY
1	D3589-045	AFT PLATE WELDMENT
1	D3589-043	FORWARD PLATE WELDMENT
1	D3589-1	ARM
2	D3589-3	ARM GUIDE
2	D3589-13	LUG
2	D3589-15	LINK
4	AN960JD4	WASHER
2	MS20392-1C7	PIN
2	MS24665-1010	COTTER PIN

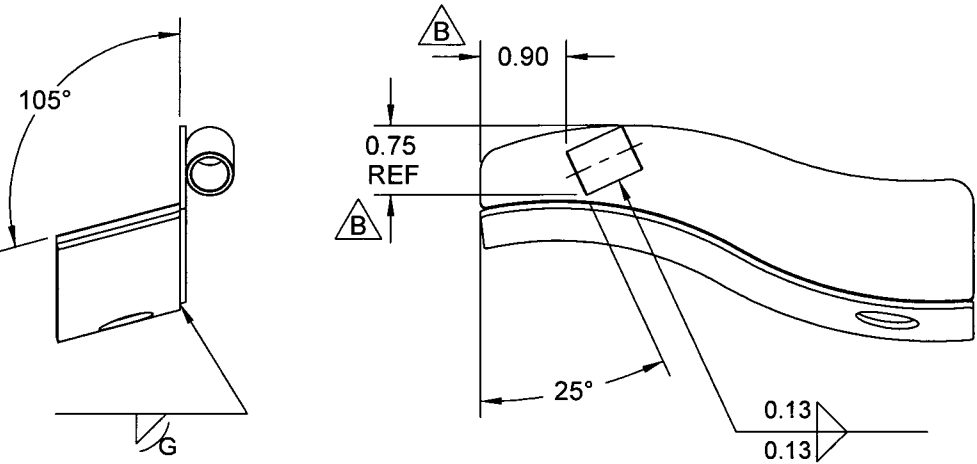
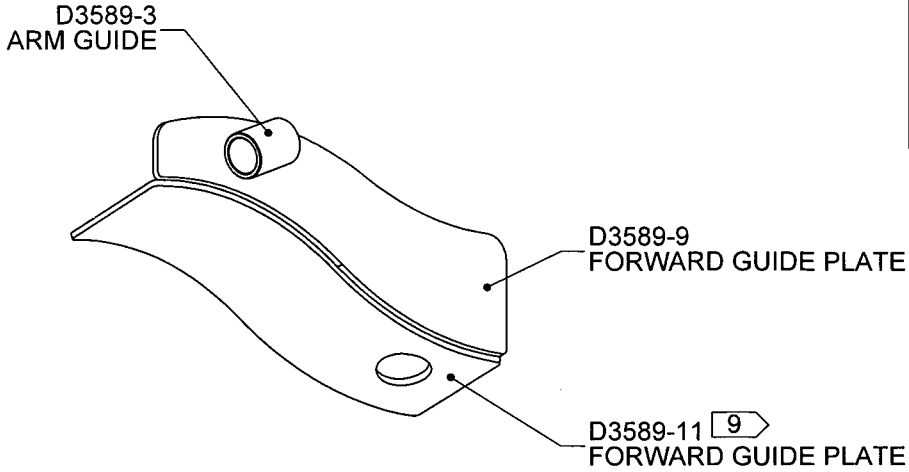
DETAIL B: WELDING AND  
LINK ASSEMBLY DETAIL  
SCALE 2X  
2 PL

DETAIL A: LINK ASSEMBLY DETAIL  
SCALE 2X  
2 PL

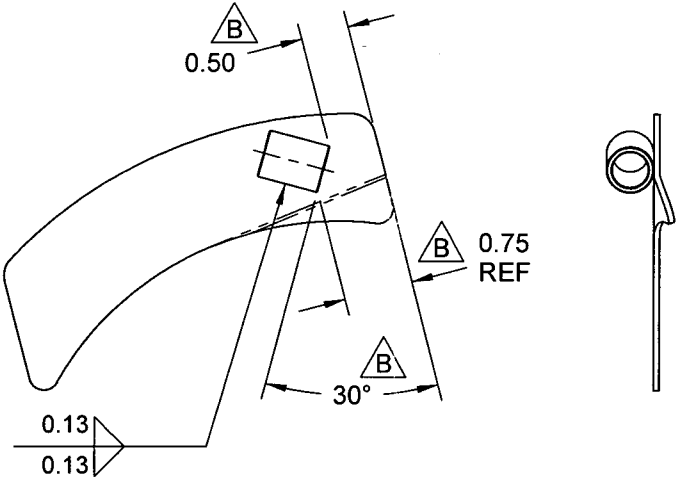
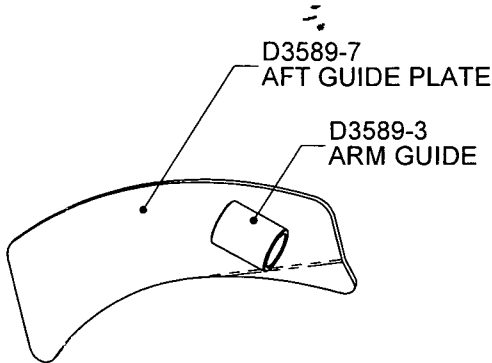
- D3589-041 NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-041" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.74 lbs
  - 8) WELDING: PER DART QSI 004
  - 9) IDENTIFIED PARTS ARE LOOSE ON D3589-1 ARM
  - 10) INSTALL COTTER PIN IN ACCORDANCE WITH MS33540

B	REDESIGN FOR PROPER FIT: 0.90 AND 0.75 REF WERE 1.97 AND 0.60 (ZN C6-2); 0.50 WAS 1.89 (ZN C3-2); 0.75 REF REPLACES 2.01 (ZN C2-2); 30 ° WAS 15° (ZN B2-2); 19.00 WAS 18.88 (ZN D4-4)	MB	08.06.25
A	NEW ISSUE	MB	08.05.29
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3589	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		LATCH ASSEMBLY	NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

QTY -043	QTY -045	P/N	DESCRIPTION
X		D3589-043	FORWARD PLATE WELDMENT
	X	D3589-045	AFT PLATE WELDMENT
1	1	D3589-3	ARM GUIDE
	1	D3589-7	AFT GUIDE PLATE
1		D3589-9	FORWARD GUIDE PLATE
1		D3589-11	FORWARD GUIDE PLATE



**D3589-043 FORWARD PLATE WELDMENT**



**D3589-045 AFT PLATE WELDMENT**

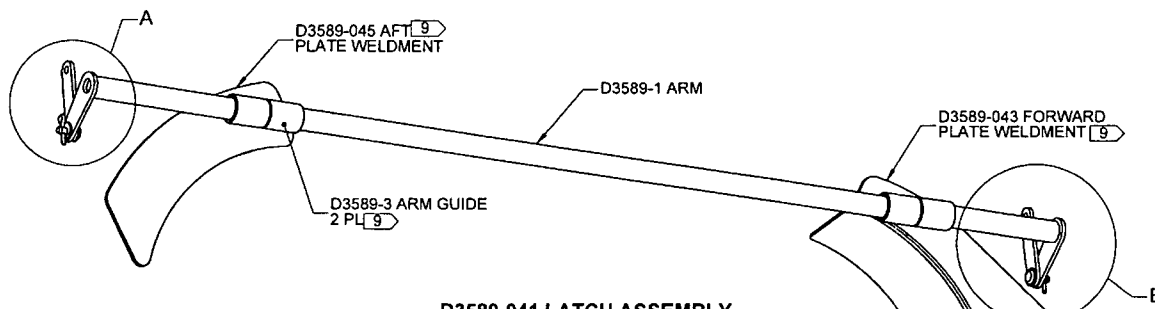
40366

- D3589-043/-045 NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-0XX" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT:
    - D3589-043 = 0.23 lbs
    - D3589-045 = 0.10 lbs
  - 8) WELDING: PER DART QSI 004
  - 9) FORM D3589-11 TO FIT D3589-9 MATING EDGE

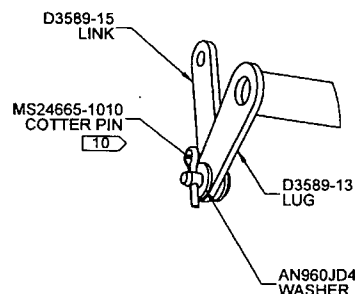
DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D3589</b>	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		<b>LATCH ASSEMBLY</b>	NTS
DATE	<b>08.06.25</b>	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



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2	MS20392-1C7	PIN
2	MS24665-1010	COTTER PIN

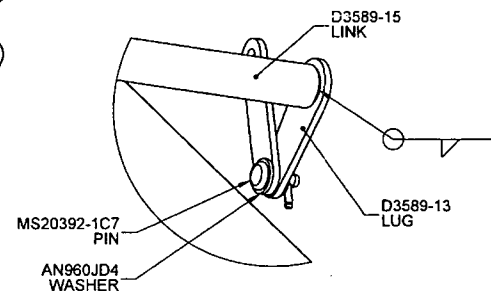


**D3589-041 LATCH ASSEMBLY**



**DETAIL A: LINK ASSEMBLY DETAIL**

SCALE 2X  
2 PL



**DETAIL B: WELDING AND  
LINK ASSEMBLY DETAIL**

SCALE 2X  
2 PL

**RELEASED**  
E9626514P

B	0.90 AND 0.63 REF WERE 1.97 AND 0.60 (ZN C6-2); 0.50 WAS 1.89 (ZN C3-2); 0.75 REF REPLACES 2.01 (ZN C2-2); 28" WAS 15" (ZN B2-2); 15.00 WAS 18.88 (ZN D4-4); REDESIGNED D3589-9 (ZN A6-6) AND D3589-11F (ZN C2-3) REASON: REDESIGN FOR PROPER FIT AND TO MATCH TESTED CONFIGURATION	MB	08.06.25
A	NEW ISSUE	MB	08.05.29
REV.	DESCRIPTION	BY	DATE
DESIGN	JH		
DRAWN	JH		
CHECKED	PH		
MFG. APPR.	JS		
APPROVED	JS		
DE APPR.	JH		
DATE	08.06.25		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3589</b> TITLE <b>LATCH ASSEMBLY</b> REV. B SHEET 1 OF 8 SCALE NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

**D3589-041 NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.73 lbs
- 8) WELDING: PER DART QSI 004 USING DT9033
- 9) IDENTIFIED PARTS ARE LOOSE ON D3589-1 ARM
- 10) INSTALL COTTER PIN IN ACCORDANCE WITH MS33540

40366